

Work Order ID 53128



Page 1

October 23, 2009 8:00:49 AM

Item ID: D2989-13

Accept



Setup Start



Revision ID: D

Stop



Item Name: Rib

Start Date: 23/10/2009 Start Qty: 4.00



Cast Item ID:

Required Date: 30/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: *PL*Date: *09/10/23*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2989	Rev D

100



Large Fab

0.00

4

Large Fab

Memo

0.00

Large Fab

1- pick D3166-3 to cut D2989-13 rib as per dwg D2989 using DT9443 jig□2-
remove identification markings□3- deburr*SAD 09-11-05*

110



QC5- Inspect part completeness to step on W/O

0.00

2/8 or 1/10

QC

Memo

0.00

*(X)**f*

Quality Control

120

Identify as per dwg & Stock Location: *WA*

0.00

(4)

Packaging

Memo

0.00

SAD 09-11-06

Packaging

Work Order ID 53128

Page 2

October 23, 2009 8:00:49 AM

Item ID: D2989-13

Accept



Setup Start



Revision ID: D

Stop



Item Name: Rib

Start Date: 23/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC21- Final Inspection - Work Order Release	0.00						09/11/06	

QC

Quality Control

Memo

0.00

MF

09-11-06

Picklist Print

Page 1

October 23, 2009 8:00:55 AM

Work Order ID: 53128**Parent Item:** D2989-13RevD**Parent Item Name:** Rib**Start Date:** 23/10/2009**Required Date:** 30/10/2009**Comments:****Start Qty:** 4.00**Required Qty:** 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3166-3RevA1



Manufactured

No

100

Each

11.6210

0.7579



SAD 09-11-05

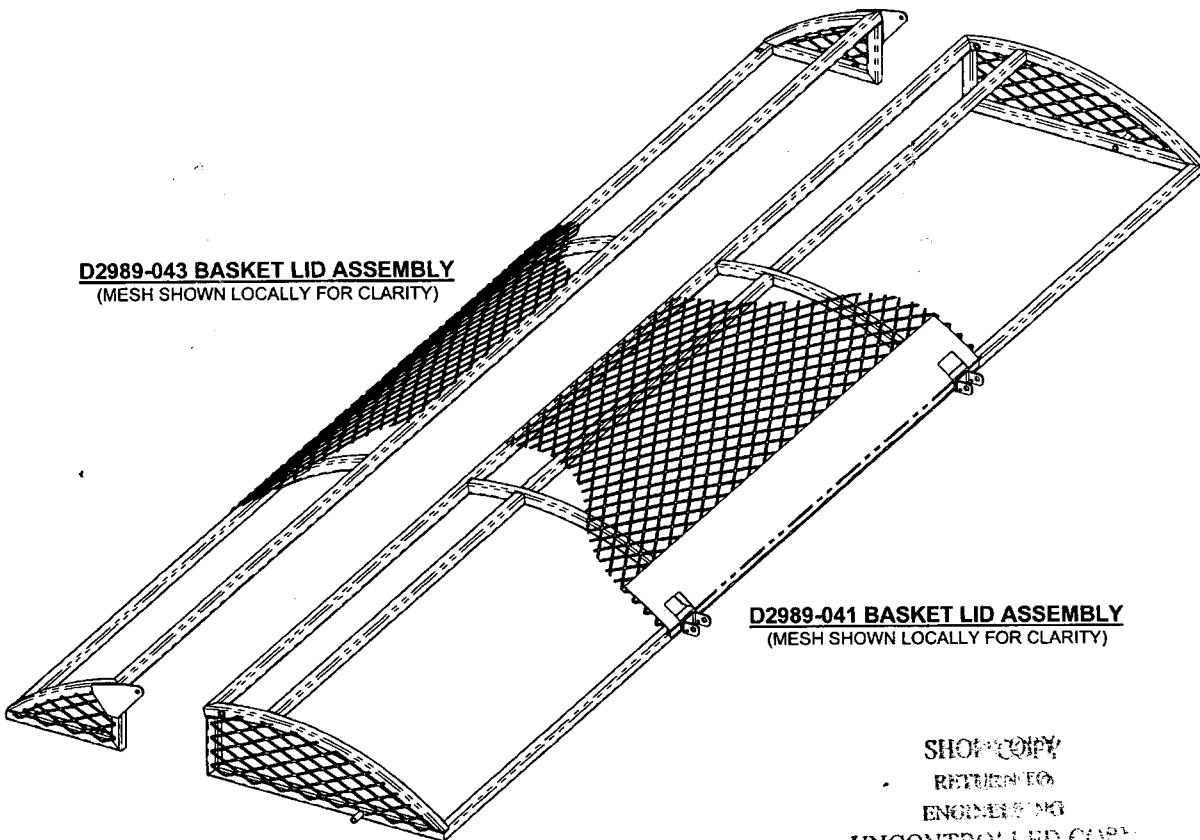
Basket Hoop

Warehouse Loc Qty Loc CodeLocation

Main Warehouse

WA	11.621	
50033	0.0527	
50618	0.5683	
51249	5	
52058	6	

0.7579



D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY

RETURN TO

ENGINEER NO

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 53128

RELEASED
08/11/18

OTES:

MATERIAL: N/A

FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: 0.005 TO 0.010 MAX

IDENTIFICATION: N/A

WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs

WELD PER DART QSI 004

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

D	REVISED -041/043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1). D3836-041 REPLACES D2989-9/15; D3836-041 REPLACES D2989-10/15; D3838-041 REPLACES D2989-1/7; D3838-042 REPLACES D2989-2/7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2/7; D3838-2; REMOVED D2327-3 (NOT INSTALLED ON D3836 DWG); D2989-9/10 (NOW ON D3836 DWG); D2989-1/2/7/15 (NOW ON D3836 DWG) AND D2989-11/12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ras</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>ras</i>	D2989	SHEET 1 OF 5
APPROVED	<i>ras</i>	TITLE	SCALE
DE APPR.	<i>ras</i>	BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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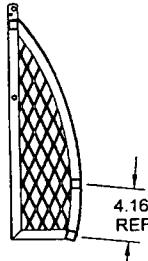
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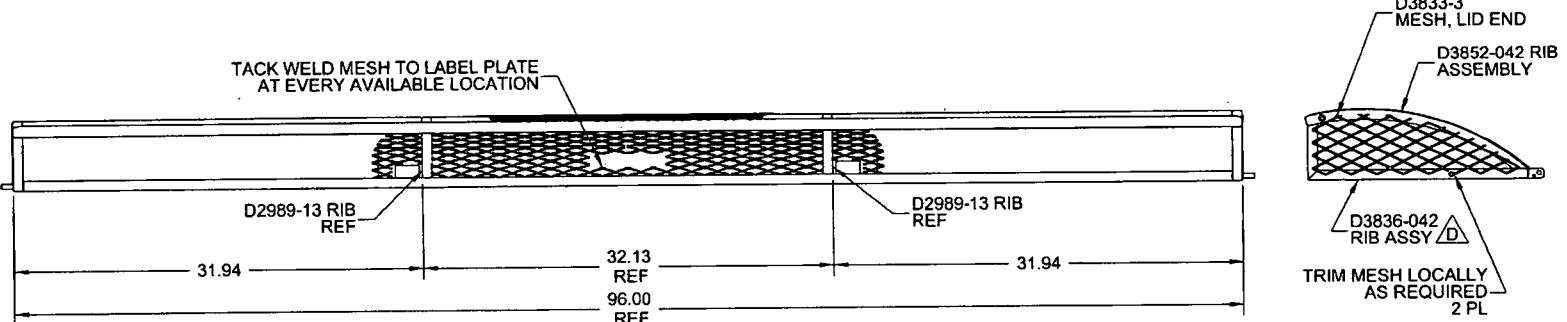
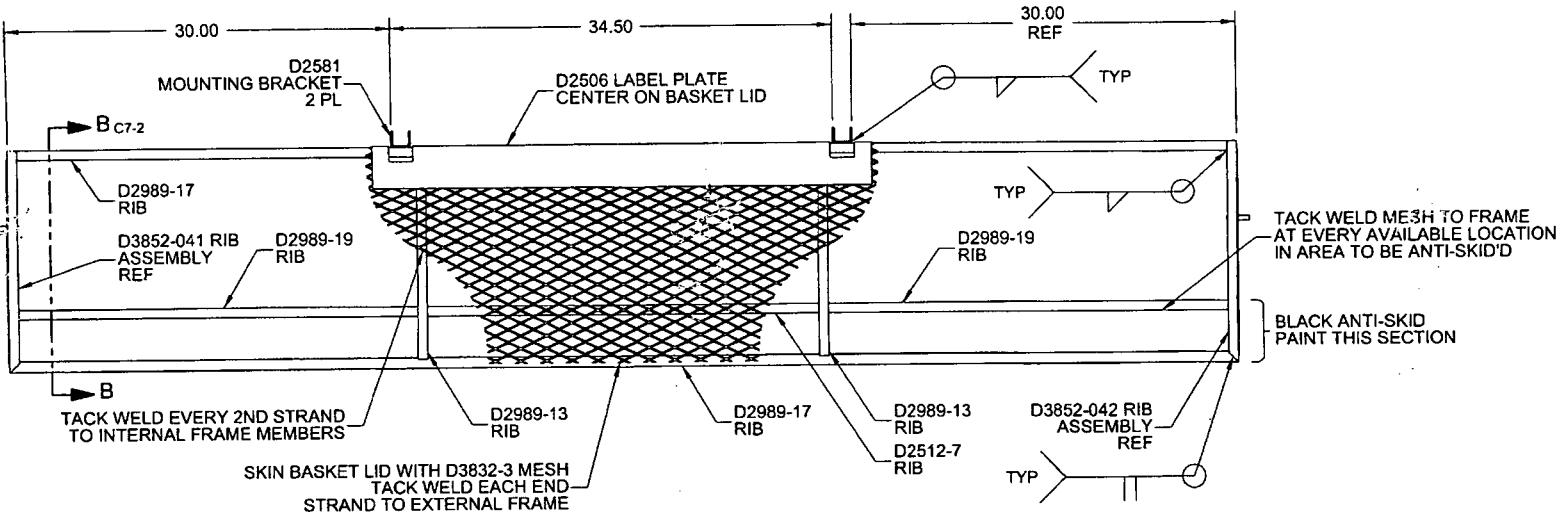
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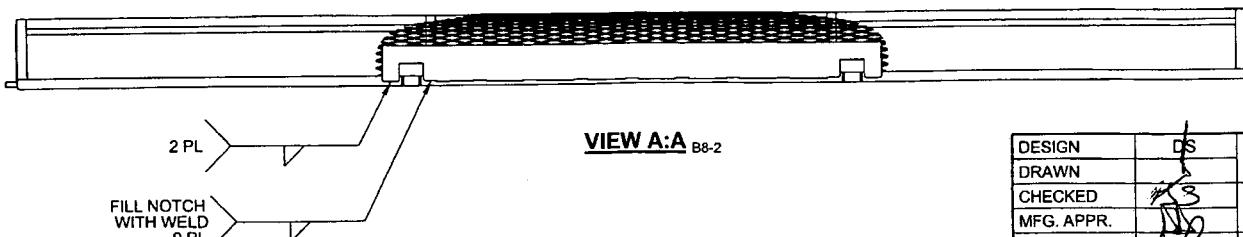
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SECTION B-B D7-2



D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)



VIEW A:A_{B8-2}

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED	<i>PS</i>	DRAWING NO.	REV. D	
MFG. APPR.	<i>TD</i>	D2989	SHEET 2 OF 5	
APPROVED	<i>MM</i>	TITLE	SCALE	
DE APPR.	<i>MM</i>	BASKET LID ASSEMBLY	NTS	
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RELEASED
08/11/2014

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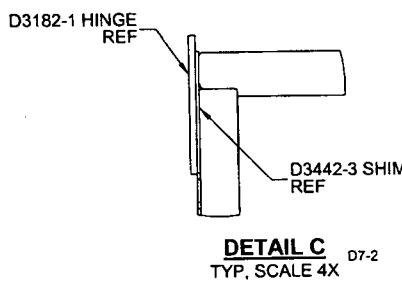
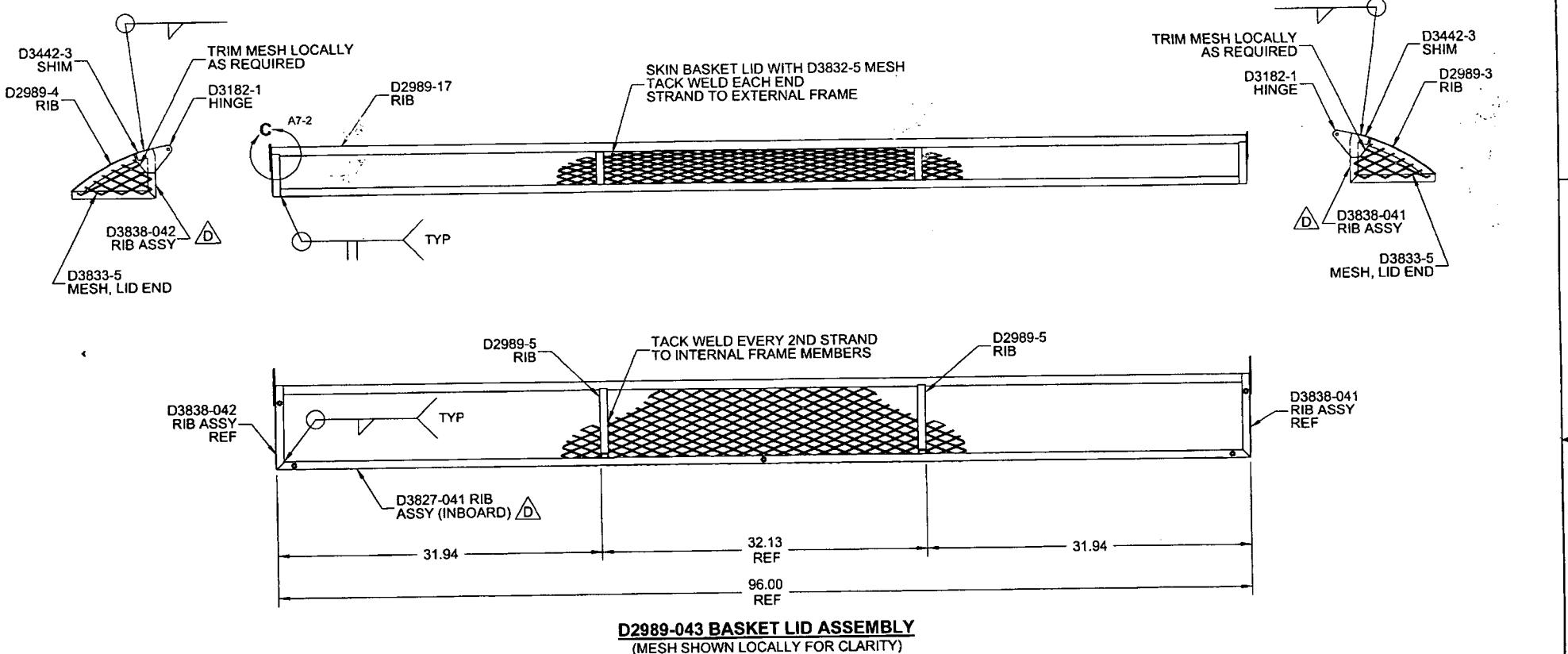
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DETAIL C

RELEASED
28/11/2010

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DESIGN	DS	DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>11/13</i>	DRAWING NO.	REV. D	
MFG. APPR.	<i>M</i>	D2989	SHEET 3 OF 5	
APPROVED	<i>M</i>	TITLE	SCALE	
DE APPR.	<i>M</i>	BASKET LID ASSEMBLY		
DATE	08.09.24	NTS		

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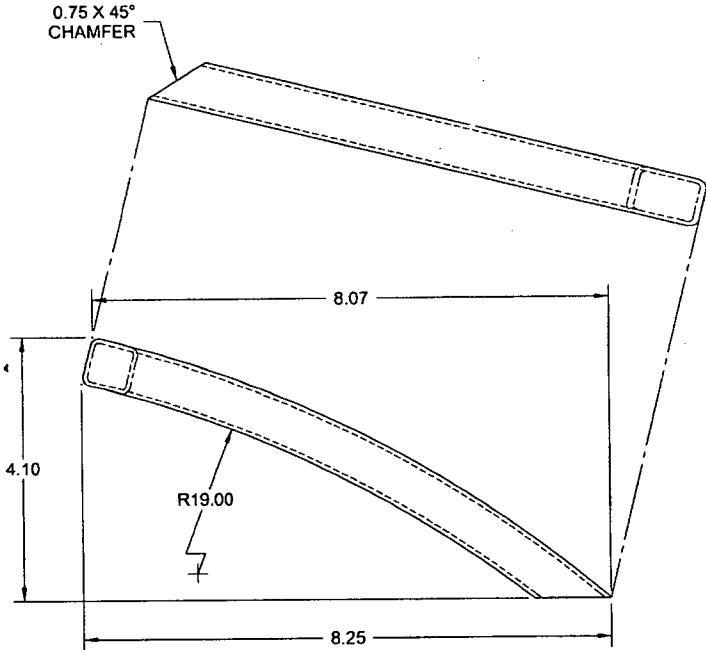
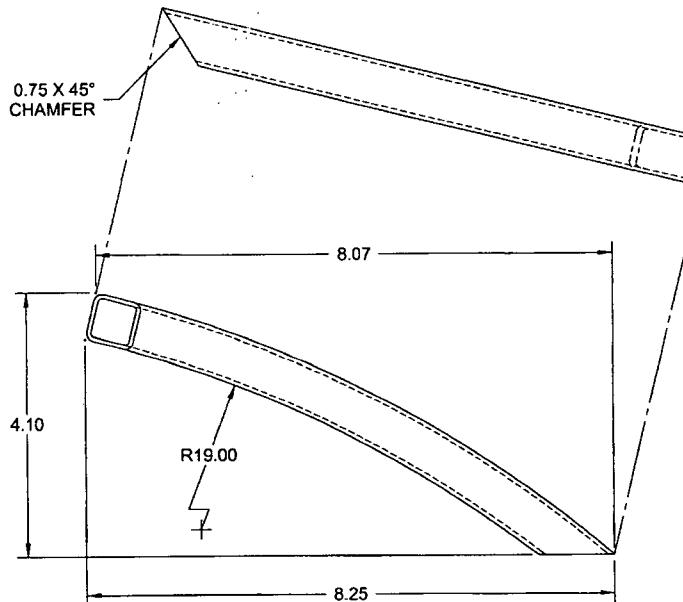
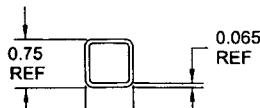
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D2989-3 RIBD2989-4 RIBRELEASED
08/11/18 ADWTYPICAL SECTION
VIEW

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY NTS	
DATE 08.09.24		COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

OTES:
) MATERIAL: D3166-3 BASKET HOOP
) FINISH: NONE
) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
) UNITS: INCHES UNLESS OTHERWISE NOTED
) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
) IDENTIFICATION: N/A
) WEIGHT: D2989-3/4 = 0.39 lbs;

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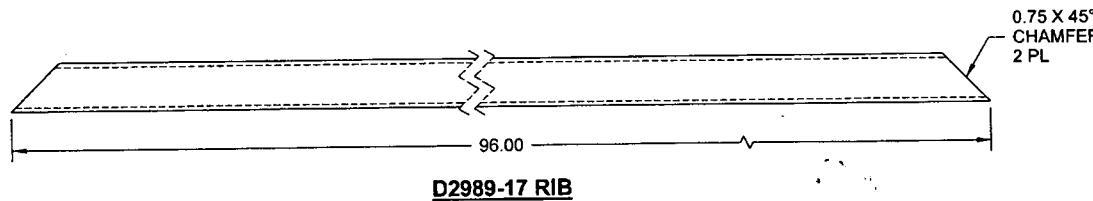
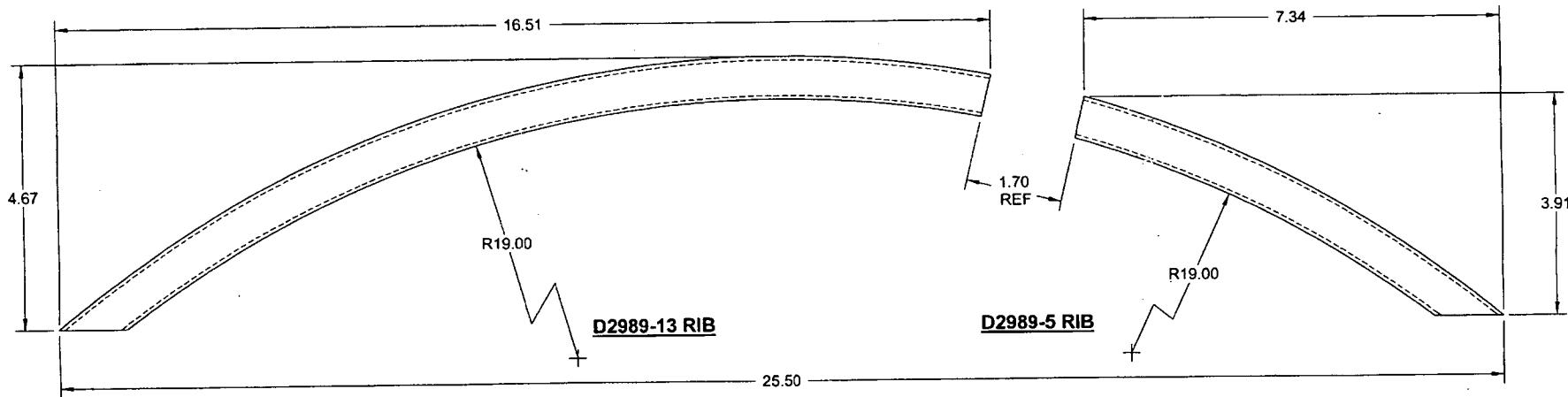
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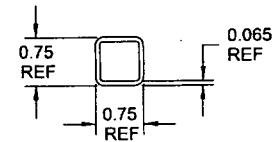
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D2989-17 RIB



D2989-19 RIB

TYPICAL SECTION
VIEWRELEASED
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	<i>✓</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>✓</i>	DRAWING NO. D2989	
MFG. APPR.	<i>✓</i>	REV. D	SHEET 5 OF 5
APPROVED	<i>✓</i>	TITLE	SCALE
DE APPR.	<i>✓</i>	BASKET LID ASSEMBLY	
DATE	08.09.24	NTS	
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